

REPRINT



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D2274

Job Sheet 171394



Part No: D2274

Job Qty: 210 ea

Part Name: Radius Block



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/31/18

Job Tracking No:

Due Date: 2/12/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV F IPP H 00.05.18 Added inspection level 8 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	210 Ea		2/10/18	0.00	0.00	Start Up Large Fab-7		
100	Shear	210 pcs		2/10/18	0.00	0.10	Shear		
110	CNC Vertical Machining	210 pcs		2/10/18	0.01	5.03	HAAS 1		
130	QC	210 pcs		2/10/18	0.00	0.00	QC8		
140	Small Fab	210 pcs		2/10/18	0.00	1.14	Small Fab		
150	HandFinish	210 pcs		2/12/18	0.00	0.54	HandFinish1		
160	QC	210 pcs		2/12/18	0.00	0.00	QC7		
170	Packaging	210 pcs		2/12/18	0.00	0.00	Packaging3		
180	QC21-SA	210 Ea		2/12/18	0.00	0.00	QC21		

Part Op 100 - blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
Descriptions: 110 - Machine as per folio D2274
140 - Tumble Deburr any rough edges after tumbling

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.125	6061-T6 Bar .750 X .125	17.8500 ft (.085 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X00.125	18	99	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Quality Other ☐					
Date : _____		Step #: _____		Approval _____ By _____					
Description Work Order Deviation Container No: S054567 Part: D2274 Job No: 171394 Serial No/Batch: S054567 Revision: _____ Inspector: _____ Date: 03/24/18									
Root Cause		Other							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Grain ☐	Over/Under tolerance ☐					
Design ☐	Operator ☐	Bending ☐	Weld ☐	Part Incorrect ☐					
Doc/Data ☐	Offset/Setup ☐	Centre Not Center ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐					
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Out of Sequence ☐	Part Moved ☐					
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Off-set ☐	Drawing ☐					
Material ☐	Use for Testing ☐	Cuffs ☐	Mislabeled ☐	Finish ☐					
Internal Transport ☐	Poor Information ☐	Crushing ☐	Fit/Function ☐	Misread ☐					
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Misaligned/off center ☐	Turning Sequence ☐					
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐							
Substation ☐	Process Improvement ☐	Marks/Chatter ☐							
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257Inches + 0.005 - 0.000	0.262 0.257		
2	Radius Block	0.750Inches $\pm$ 0.010	0.760 0.740		
3	Radius Block	0.375Inches $\pm$ 0.010	0.385 0.365		
4	Radius Block	0.125Inches $\pm$ 0.010	0.135 0.115		
5	Radius Block	0.750Inches $\pm$ 0.010	0.760 0.740		
6	Radius Block	0.063Inches $\pm$ 0.010	0.073 0.053		

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